

Work Order ID 115507

April-02-14 11:14:37 AM

115507

Page 1

Item ID: D3391-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-02 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3391	I
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100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut tube to finish length as per Dwg D3391

2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

3-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

4-Remove .030" from Fwd indexing Ridge as per Dwg D3391

5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

6-Deburr

7-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG

8-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391

9-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

DO NOT OPEN 2 MOST FWD WEARPLATE HOLES

SCRAP

DEC

14-4-21

DEC

14-4-21

Work Order ID 115507

115507

Page 3

April-02-14 11:14:37 AM

Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Mid Tube Assembly
Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
130 *130* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							

Work Order ID 115507

April-02-14 11:14:37 AM

115507

Page 4

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Revision ID:

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Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open float bag holes as per dwg
 2-C'sink float bag holes as per dwg
 3- Prepare tube for welding
 4-Bond web in place as per Dwg D3391 & QSI 015.
 Adhere for 12 hours
 A/R Sikaflex exp: 14/10/09
 batch#: 128026

NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE

DC 14/04/28

150

0.00

150

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

DAS
18
9-89

1 0 14-04-30

Work Order ID 115507

115507

Page 5

April-02-14 11:14:37 AM

Item ID: D3391-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

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Item Name: Mid Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush - <i>OK 14/04/30</i>								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

PTO
Last page.

April-02-14 11:14:37 AM

Item ID: D3391-023

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N900040100

Setup Start *NS1*

Revision ID:

Item Name: Mid Tube Assembly

Stop *NS2*

Start Date: 4/02/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/16/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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185 Pressure Wash per QSI005 4.3

0.00

185

Memo

0.00

HandFinish

Hand Finishing

AND REALODINE AS PER PAR09-043

190 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

190

Memo

0.00

Powdercoat

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

200 QC3- Inspect Part Finish

0.00

200

Memo

0.00

QC

Quality Control

April-02-14 11:14:37 AM

Page 7

[illegible]

Work Order ID 115507

April-02-14 11:14:37 AM

115507

Page 8

Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
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Item Name: Mid Tube Assembly
Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260

QC21- Final Inspection - Work Order Release

0.00


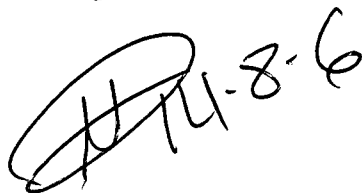
260

QC

Memo

0.00

Quality Control


 14-8-6

Picklist Print

Page 1

April-02-14 11:14:40 AM

Work Order ID: 115507

115507

Parent Item: D3391-023

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.10.20New Issue KJ/EC
 IPP B06.02.10ECN773 dwg rev.D EC
 IPP C 07.03.20 rev F dwg EC
 IPP D 07.03.28 re-format EC
 IPP E 07.10.31 ecn 1053P EC
 IPP Rev:F ECN 1056 07-11-13 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP
 Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	83.0000	1	1			
D2500-1-100									**				
Skidtube Extrusion													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				83					
				82373				22					
				86065				61					
D3389-1		Manufactured	No			140	Each	8.0000	1	1			
D3389-1									**				
Web													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				8					
				113057				8					
D3681-1		Manufactured	No			160	Each	234.0000	5	5			
D3681-1									**				
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				168					
				114884				168					
				LG001				66					
				109109				66					

DGC 14421

DC 14/04/28

①

BE1404-30

5

Picklist Print

April-02-14 11:14:40 AM

Page 2

Work Order ID: 115507

115507

Parent Item: D3391-023

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3591-1

Manufactured No

Each

88.0000

2

D3591-1

Bushing

Location

Loc Qty

Loc Code

FG

10

92873

10

FP001

78

100699

5

107918

36

109107

37

ALS4-1032-130

AELS4-1032-130 Purchased

No

230

Each

9,937.000

20

20

ALS4-1032-130

Rivnut

Location

Loc Qty

Loc Code

FP001

9832

M128649

9832

ST279

48

M128211

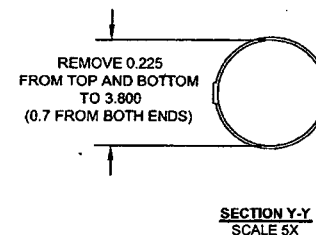
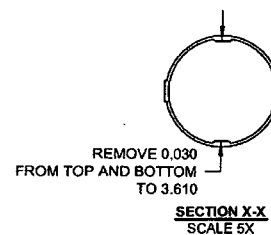
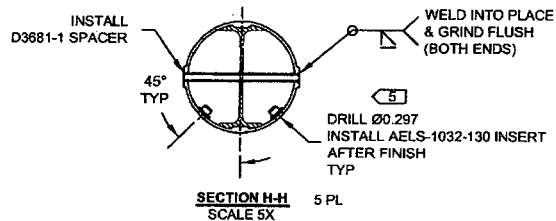
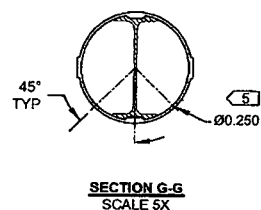
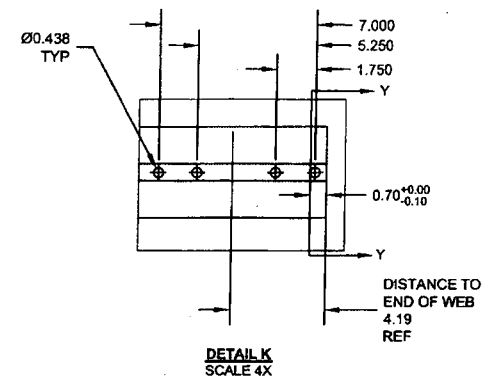
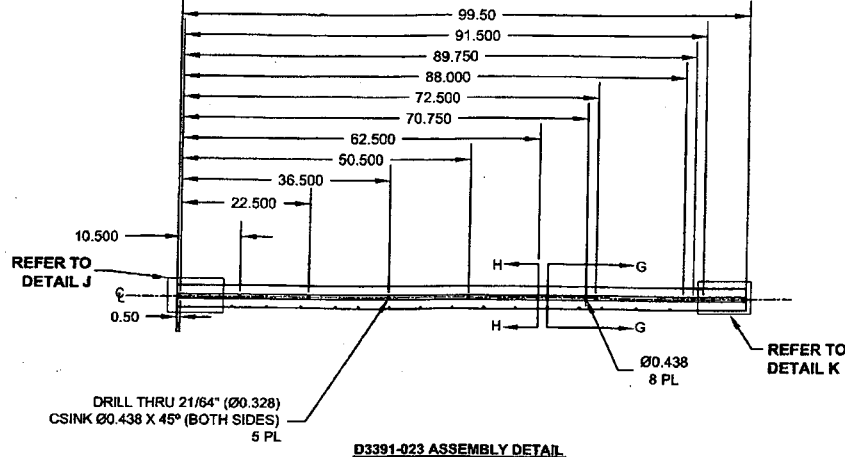
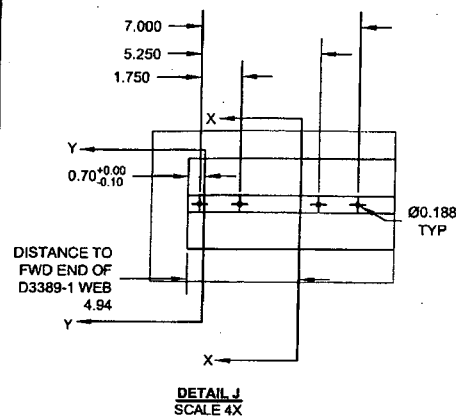
48

st510

57

M126109

57



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

115507 MJS
140402

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AA Date: 14/12/13QA Closed: 800 Date: 14/12/11

Work Order: <u>115507</u> Part No. <u>D 3391-023</u> NCR No. <u>WCR 14-4110</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input checked="" type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input checked="" type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input checked="" type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	14/7/16	1	1	DEEP CORROSION IN OUTER SURFACE. PART WAS STORED IN ALUMINUM/ACID ROOM TOO LONG Re Parts were not kept in a clean area. / <i>Pool House (Facility)</i>	DAS 12 9-89 14/7/16	SCRAP. And Destroy No Repair	14-8-16	14-8-16	DAS 16 9-89 14/02/16
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input checked="" type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other